Coating Procedures

NOTE: This section covers the application of the soft chipping primer to the replacement part.

1. Sanding the replacement part

⚠WARNING Wear goggles or safety glasses to prevent eye injury.

Sand the area to be painted with #240-#400 sandpaper.

NOTE:
- Do not oversand the edges or corners of the part.
- Do not expose bare metal.

2. Air blowing/degreasing

⚠WARNING
- **Do not use high air pressure; use only an approved, 210 kPa (2.1 kgf/cm^2, 30 psi) air nozzle.**
- **Wear goggles or safety glasses to prevent eye injury.**
- **Paint thinner is flammable. Store it in a safe place, and keep it away from sparks, flames or cigarettes.**

Clean the surface with compressed air and wax and grease remover.

3. Masking
- Place masking tape or paper around the surface to be painted.
- Cover as wide an area as possible with tape or paper to keep primer from spreading.

4. Spraying chipping guard primer
- Stir the primer thoroughly.
- Put the primer in a beaker and weigh the needed amount of primer to be used.
- Mix the hardener into the primer, following the manufacturer's instructions.

NOTE: Measure the primer and hardener so they are in correct ratio.

Item	Primer : Hardener
*High Primer Surfacer 2C	10 : 1
*Auto Primer Surfacer Mighty	5 : 1

- Add the specified thinner to the mixture of hardener and primer to attain the proper viscosity for spraying.
  2C 68°F (20°C) 18 sec ± 1
- These substances are not available in the using DuPont's 123 Vinyl Coating, or Sherwin-Williams' Vinyl Gravel Guard. Follow the manufacturer's instructions for application.
- Use the following materials:
  - Spies Hecker Permacron 4:1 Surfacer 4:1 (Hoechst)
  - Standox 2K 4:1 Special Filler (Herberts)
- Once mixed with the hardener and thinner, the primer must be used within the times shown below.

Temperature		41°F (5°C)	50°F (10°C)	68°F (20°C)
Time	High Primer Sufacer 2C	30H	24H	8H
	Auto Primer Surfacer Mighty	4H	3.5H	3H

⚠WARNING
- **Most paints contain substances that are harmful if inhaled or swallowed. Read the paint label before opening the container. Spray paint only in a well ventilated area.**
- **Cover spilled paint with sand, or wipe it up at once.**
- **Wear an approved respirator, gloves, eye protection and appropriate clothing when painting. Avoid contact with skin.**
- **If paint gets in your mouth or on your skin, rinse or wash thoroughly with water. If paint gets in your eyes, flush with water and get prompt medical attention.**
- **Paint is flammable. Store it in a safe place, and keep it away from sparks, flames, or cigarettes.**

(cont'd)

Soft Chipping Guard Primer Coat

Coating Procedures (cont'd)

- Fill the gun's paint cup with the primer. Use a strainer when pouring the primer into the cup.

- Primer should never be applied to a dirty or greasy surface. Before spraying, blow dust and dirt off the surface and clean with wax and grease remover.

(Method of spraying)

- Do not try to cover the surface with one heavy coat. Apply several thin coats.

NOTE:
- Spray coat 4-5 coats to get 20 microns of thickness, as one coat deposits 5-7 microns.
- Spray the primer at 250-300 kPa (2.5-3.0 kgf/cm^2, 35.6-42.7 psi) pressure. Spraying with improper air pressure will cause imperfections.
- Open the gun 3-4 turns.
- Wipe up unwanted primer immediately with thinner.

5. Cleaning spray gun

- After spraying, be sure to clean the spray gun thoroughly with thinner or solvent.

- The gun will be permanently clogged if the primer is allowed to dry.

6. Drying

- After spraying the chipping guard primer, air-dry for 7-10 minutes to evaporate the thinner in the primer. Then dry it with infrared lamps at 176°F (80°C) for 30-40 minutes.

NOTE: Insufficient baking may cause pinholes if the primer coat is too thick.

- The temperature lamps and drying time recommendations should be followed closely.

7. Intermediate and Top coating

- Sand the chipping guard primer film with #280-#400 sandpaper.

- Follow the intermediate/top coating Procedures (see page 8-11).

Temperature		41°F (5°C)	68°F (20°C)	86°F (30°C)	140°F (60°C)	176°F (80°C)
Time	Before sanding	8 – 13H 6 – 10H	3.5 – 5H 4 – 5H	2 – 3H 2 – 4H	30 Min. 15 – 20 Min.	20 Min. 10 – 15 Min.
Minimum time	Before painting	8H 10 – 18H	4H 6 – 8H	3H 4 – 8H	30 Min. 20 – 40 Min.	20 Min. 15 – 30 Min.

NOTE: The upper line of time shows specifications for High Primer Surfacer 2C, and the lower line Auto Primer Surfacer Mighty.